

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002628**Date Inspected:** 08-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C.M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Side Plates and Bottom Plates**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Mahlon Lindenmuth, arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates. This functions included but are not limited to the grinding of areas where temporary welds for strongbacks are located and bevel preparation for Complete Joint Penetration welds (CJP) on Side Plates and Bottom Plates. Member identification and the work performed on the member are as follows:

SEG020A-004: Complete Joint Penetration weld joining BP22A to BP23A has been backgouged and prepped, by grinding, for Magnetic Particle (MT) testing and welding.

SEG017A: Heat straightening of the member was performed by placing (3) four ton weights on the CJP weld splice, joining SP60 to SP48. The heat straightening was performed using an approved procedure and was monitored by ZPMC Quality Control personnel.

SEG013A-003: Heat straightening of the member was performed by placing (2) four ton weights on the CJP weld splice, joining BP1A to BP2A. The heat straightening was performed using an approved procedure and was monitored by ZPMC Quality Control personnel.

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## WELDING INSPECTION REPORT

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Panel Point(PP) 23/Segment 3BE and Panel Point 20/Segment 3AE: ZPMC personnel were in the process of installing the temporary bolts joining the tube steel cross bracing to the FL2-1 and FL2-2 connection plates. The connection plates have not been welded to the FL2-1 member at this time.

OBG Jig Fixture(South): Segment 3BE (SEG16) is currently erected in the jig. The segment sections erected are C5,D6 and E7. Caltrans QA observed ZPMC personnel performing alignment checks of sections C5 to D6 and E7 to D6.

### Summary of Conversations:

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lindenmuth,Mahlon	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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